

Work Order ID 83011

Thursday, April 12, 2012 12:32:12 PM

83011

Page 1

Item ID: D3524-1

Revision ID:

Item Name: Lower Plate

Start Date: 4/12/2012 Start Qty: 2.00

Required Date: 4/24/2012 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan: PDate: 12-04-12 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3524

Rev A

100

0.00

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut Blanks 2.750" Long

0.00

27 12-05-14 (Y2)

110

0.00

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1- Mill as per Polio FA699 Rev: AA & Dwg D3524 Rev: A 2-Deburr
per dwg D3443

0.00

2 0 12/05/15

120

0.00

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

2 0 12/05/15Setup Start ***NS1***Stop ***NS2******N900040100***

Cust Item ID:

Customer:

Run Start ***NR1***Stop ***NR2***

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83011

Thursday, April 12, 2012 12:32:12 PM

83011

Page 2

Item ID: D3524-1

Revision ID:

Item Name: Lower Plate

Start Date: 4/12/2012 Start Qty: 2.00

Required Date: 4/24/2012 Req'd Qty: 2.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

2

Cust Item ID:

2

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

12-5-15

2

4

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

2

12-5-16

150

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE.

10-10

10-40

2X

m-l 12/5/17

320°F

M117338

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83011

Thursday, April 12, 2012 12:32:12 PM

83011

Page 3

Item ID: D3524-1

Revision ID:

Item Name: Lower Plate

Start Date: 4/12/2012 Start Qty: 2.00

Required Date: 4/24/2012 Req'd Qty: 2.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2******2***

Cust Item ID:

2

Customer:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

2 6 BL 12-5-17

170

Identify as per dwg & Stock Location: **ST 53.**

0.00

170

Packaging

Memo

0.00

Packaging

2 SP 12-5-22

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/5/22 JF
MK
12-05-20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, April 12, 2012 12:32:16 PM

Page 1

Work Order ID: 83011

Parent Item: D3524-1

Parent Item Name: Lower Plate

83011

D3524-1

Start Date: 4/12/2012

Required Date: 4/24/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-04-18 EC
IPP Rev:B Now CNC Machined 07-09-24 JLM verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.375X03.00 0		Purchased	No			110	f	14.1800	0.2252	0.474105			

M6061T6B0 375X03 000
6061T6 BAR .375 X 3.00

**

RT 12-05-14

Location

MAT001

Loc Qty

14.18

Loc Code

105225

4.6

18237

9.58

x.474105

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	83011
Description: Lower Plate		Part Number:	D3524-1
Inspection Dwg: D3524	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.501	✓			
2.00	+/-0.030	2.001	✓			
1.625	+/-0.010	1.625	✓			
1.063	+/-0.010	1.065	✓			
0.44	+/-0.030	0.439	✓			
0.47	+/-0.030	0.468	✓			
1.250	+/-0.010	1.251	✓			
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	0.240	✓			
0.20 x 45°	+/-0.030 x 0.5°	0.200 x 45°	✓			
Ø0.750	+0.005/-0.000	Ø 0.750	✓			
Ø0.144	+0.005/-0.001	Ø 0.1455	✓			
Ø0.250 x 100°	+0.005/-0.001 x 0.5°	Ø 0.246 x 100°	✓			
Ø0.711	+/-0.010	Ø 0.705	✓			

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	12/05/15	Date:	12-5-15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.10.01	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTSHO
RETURN TO
ENGINEERING

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED H	DRAWING NO. D3524	REV. A SHEET 1 OF 3
DATE 07.07.24	TITLE UPPER AND LOWER PLATE		SCALE 1:1
REV A	DATE 07.07.24	DESCRIPTION NEW ISSUE	

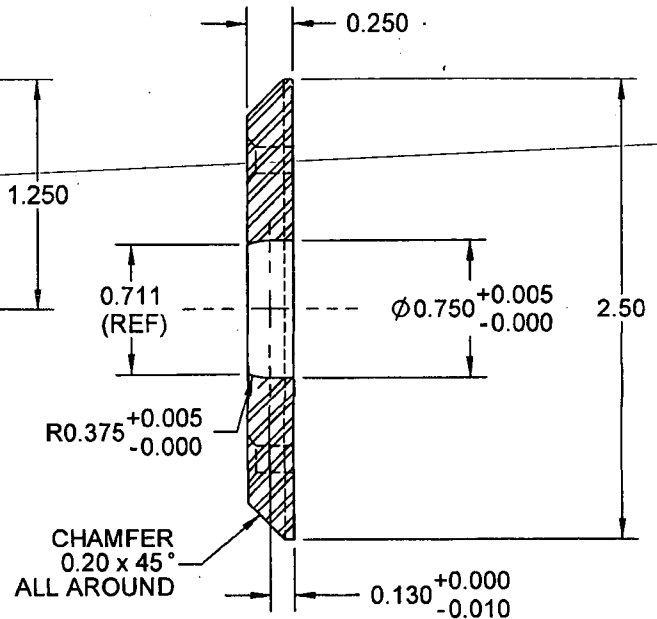
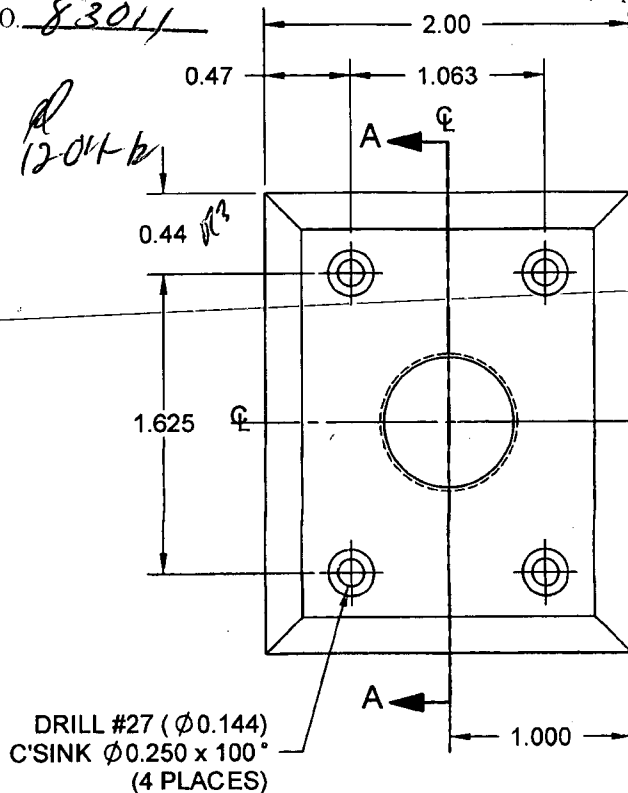
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

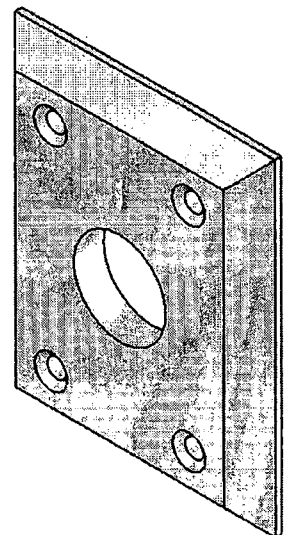
WITHOUT NOTICE

WORK ORDER

NO. 83011

**D3524-1 LOWER PLATE****RELEASED**
07.08.03**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART SYMMETRIC ABOUT ϕ



COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

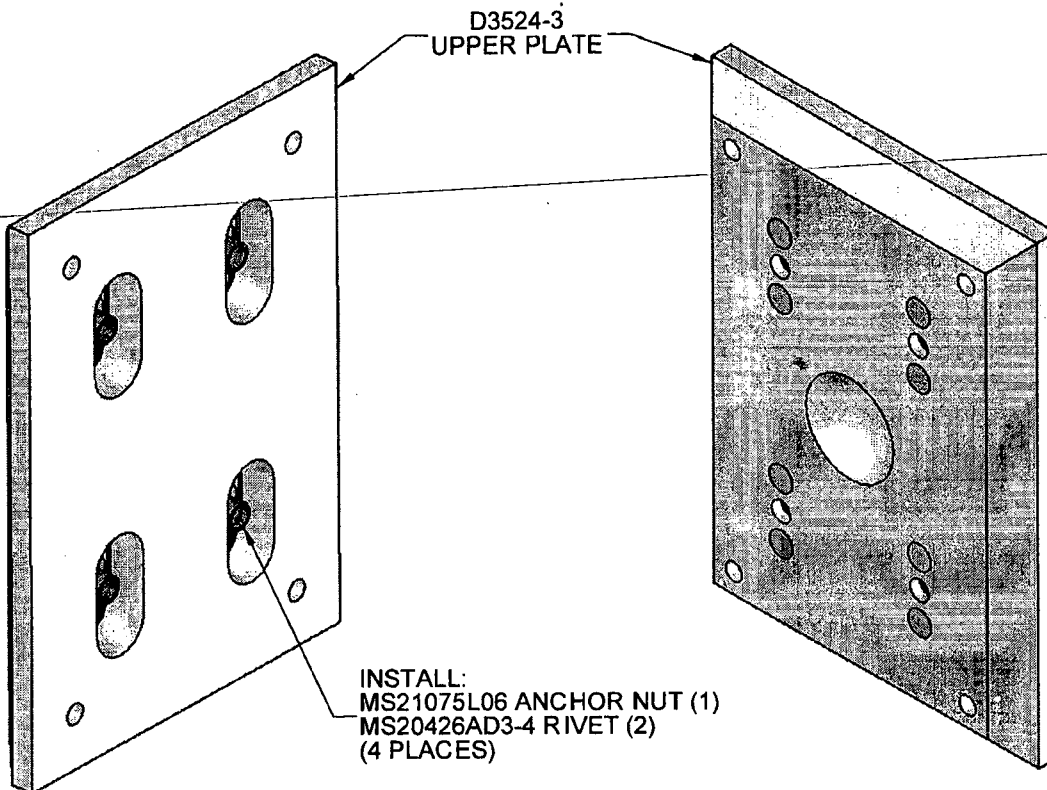
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3524	REV. A SHEET 2 OF 3
DATE 07.07.24		TITLE UPPER AND LOWER PLATE	SCALE 1:1

8304

**D3524-041 UPPER PLATE ASSEMBLY****RELEASED**
07.08.03 #**PARTS LIST:**

QTY	PIN	DESCRIPTION
X	D3524-041	UPPER PLATE ASSEMBLY
1	D3524-3	UPPER PLATE
4	MS21075L06	ANCHOR NUT
8	MS20426AD3-4	RIVET

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

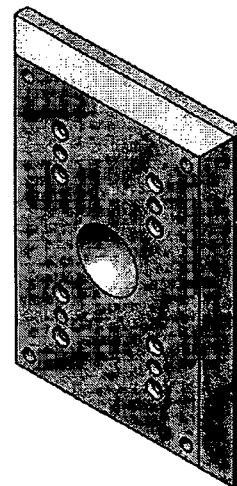
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN	C.B.	DRAWN BY	C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A SHEET 3 OF 3
CHECKED	C.E.	APPROVED	[Signature]		
DATE	07.07.24	TITLE	UPPER AND LOWER PLATE		



NOTES:

- NOTES:**
- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
 - 6) PART SYMMETRIC ABOUT C

RELEASED
07-08-03

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

COPYRIGHT © 2007 BY DART AEROSPACE LTD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries